

Ship today if possible 09-05-12 Dart Aerospace Ltd.

Date: Tuesday, 12/05/2009 12:49:23 PM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: AS350-9267 REV.2
Job Number	: 47908		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: AS3509267
This Issue	: 12/05/2009 S.O. No. :	Drawing Number	: AS350-9267
Prsht Rev.	: NC	Project Number	:
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 34448	Material	:
Written By	: <u>W</u>	Due Date	: 12/05/2009 Qty: 3 Um: Each
Checked & Approved By	: <u>W</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	AS3509268	Half Bracket
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 1.5000 Each(s)
TUBE

17679 11 09-05-12

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

CUT PER DRWG

N/A already cut

3.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
Powder coat white as per QSI005

START TIME 3:15
OVEN TEMP. 400°
FINISH TIME 3:45

BR 09-05-12 (2)

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-12 (3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
-Install rubber as per Drwg AS350-9228 D3195
-assemble as per drwg AS350-9267

m42122 Rubber
Glue: m109410 09-05-13 (3)

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Drawing Name: AS350-9267 REV.2

Job Number: 47908

Part Number: AS3509267

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN417A

Bolt



M1090061



(3X)

Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)
Bolt

9/5/12

SL

7.0

AN960416

Washer



M119356



M1108246

Comment: Qty.: 8.0000 Each(s)/Unit Total: 24.0000 Each(s)
Washer

9/5/12

SL

8.0

MS20365428

NUT



M1104517



(3X)

Comment: Qty.: 4.0000 Each(s)/Unit Total: 12.0000 Each(s)
NUT

9/5/12

SL

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/05/13

(X3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



(3X)

Comment: PACKAGING RESOURCE #1
Identify & Stk

483

9/5/13

SO

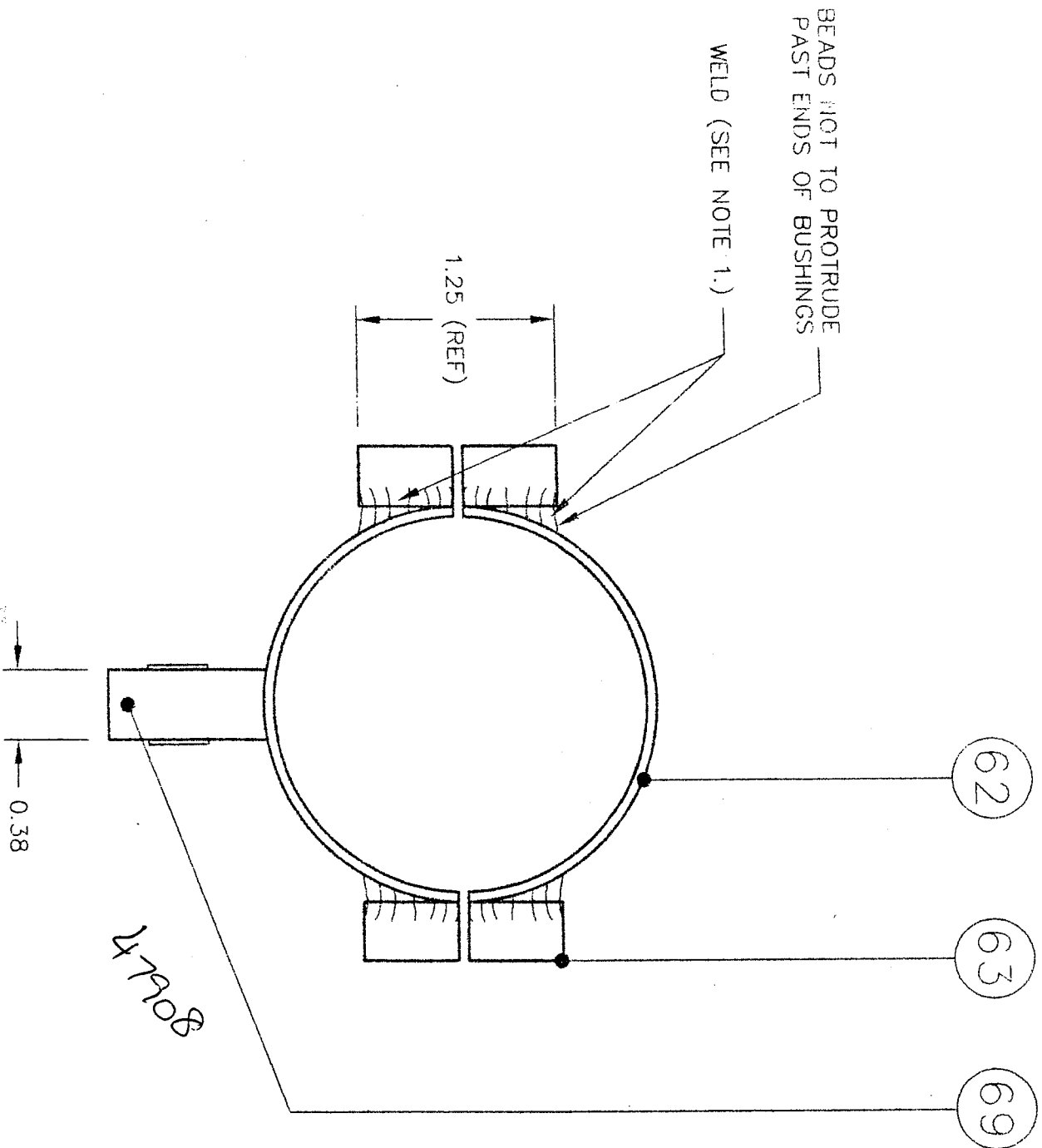
Job Completion



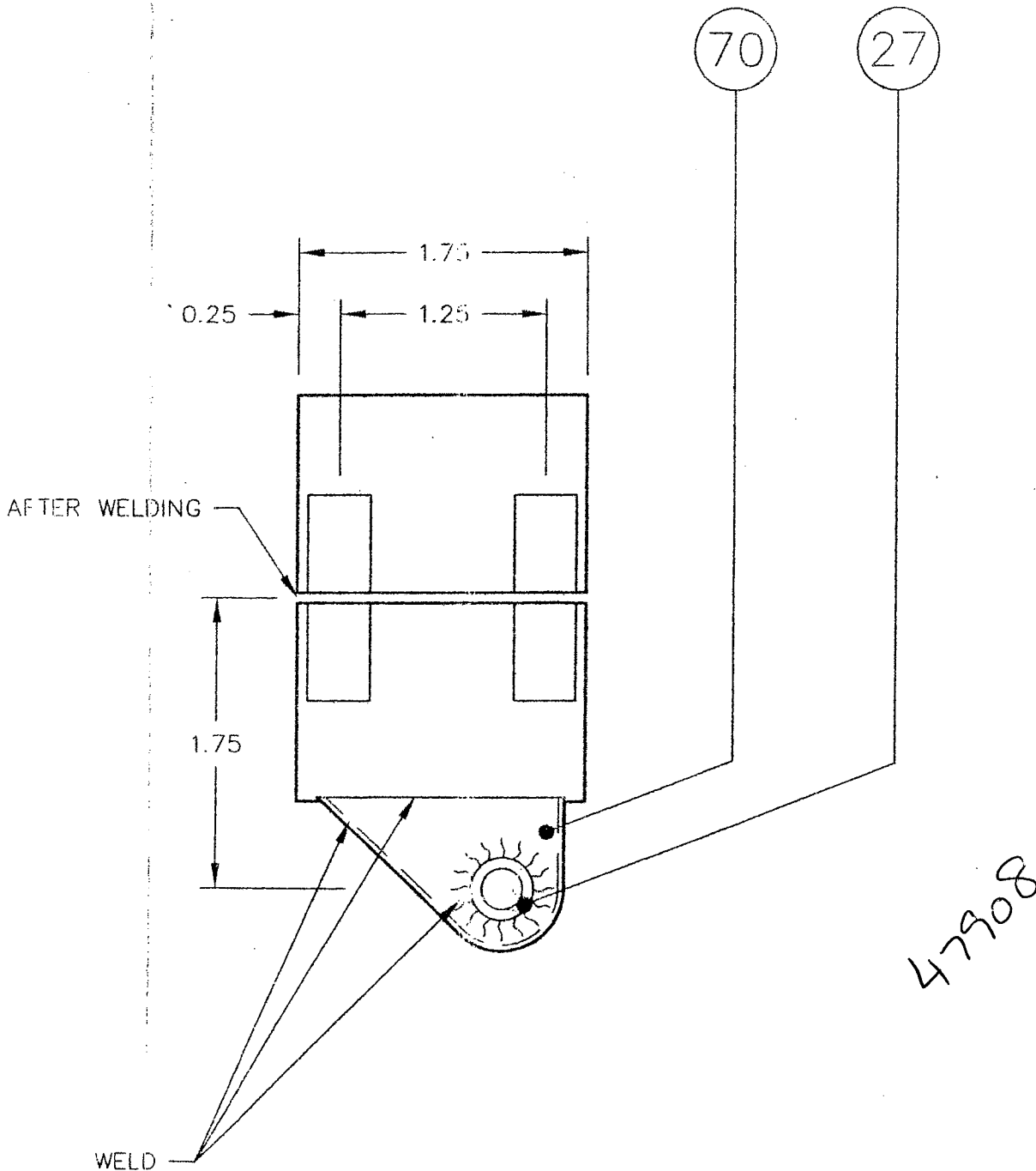
MF
09-05-13

QC21 - 09/05/13

REV.	
1	LUG.
2	NOTE



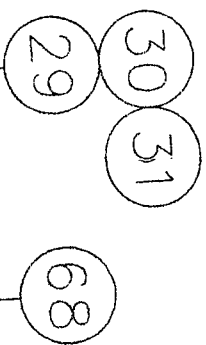
DESCRIPTION OF CHANGE	INITIALS	DATE
MODIFIED. THICKNESS OF BRKT CHANGED TO 0.38".	E. B.	27 DEC 92
BEADS ADDED TO ITEM 68	D. W.	6 OCT 00



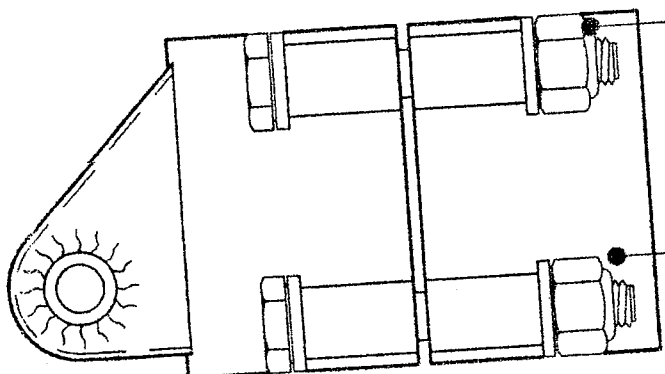
AS350-9267

AND/OR
PIED, OR

D. AND/OR
TION



Handwritten note:
1/2" diameter
1/2" diameter

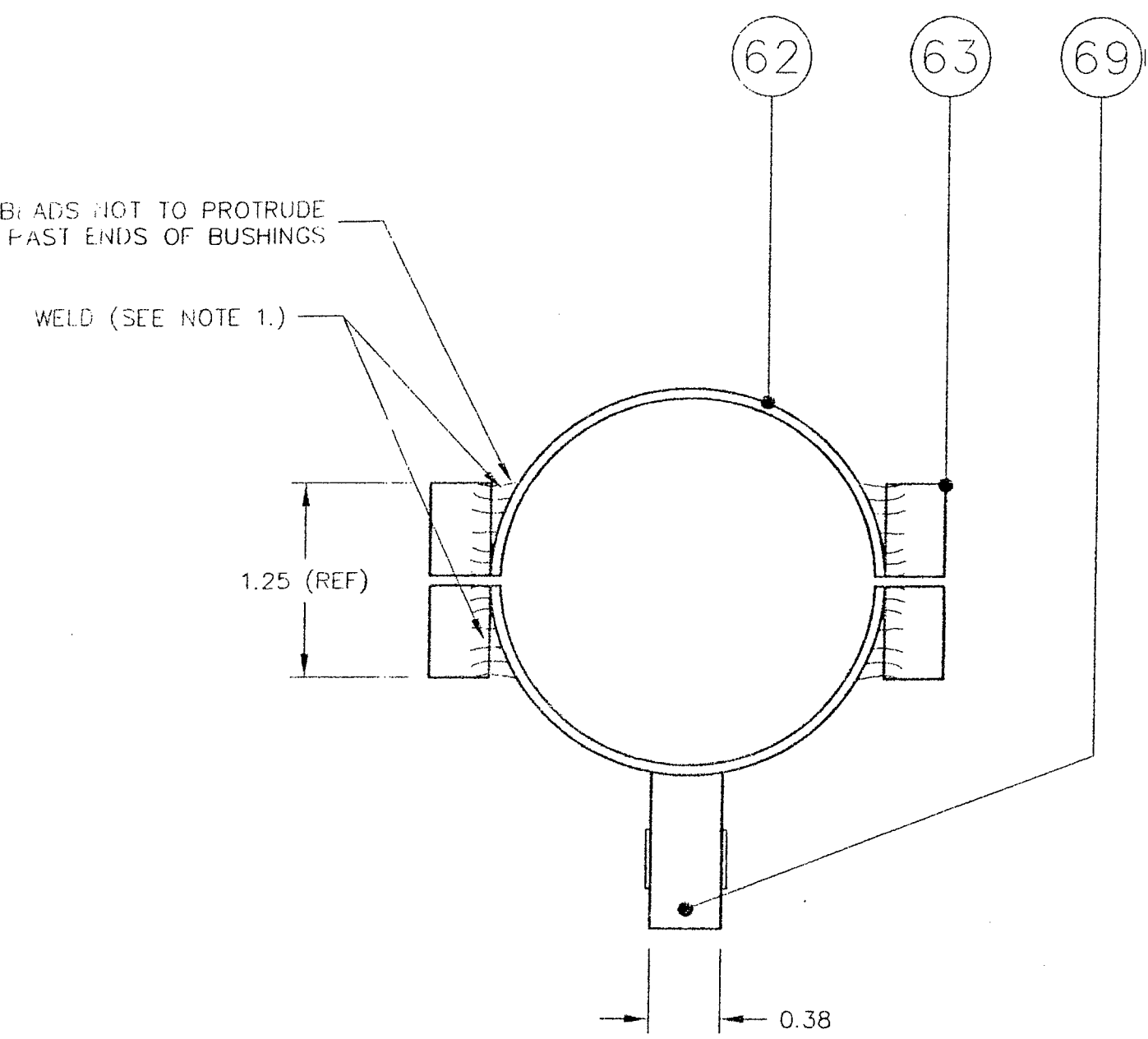


WELD BEA
PAC

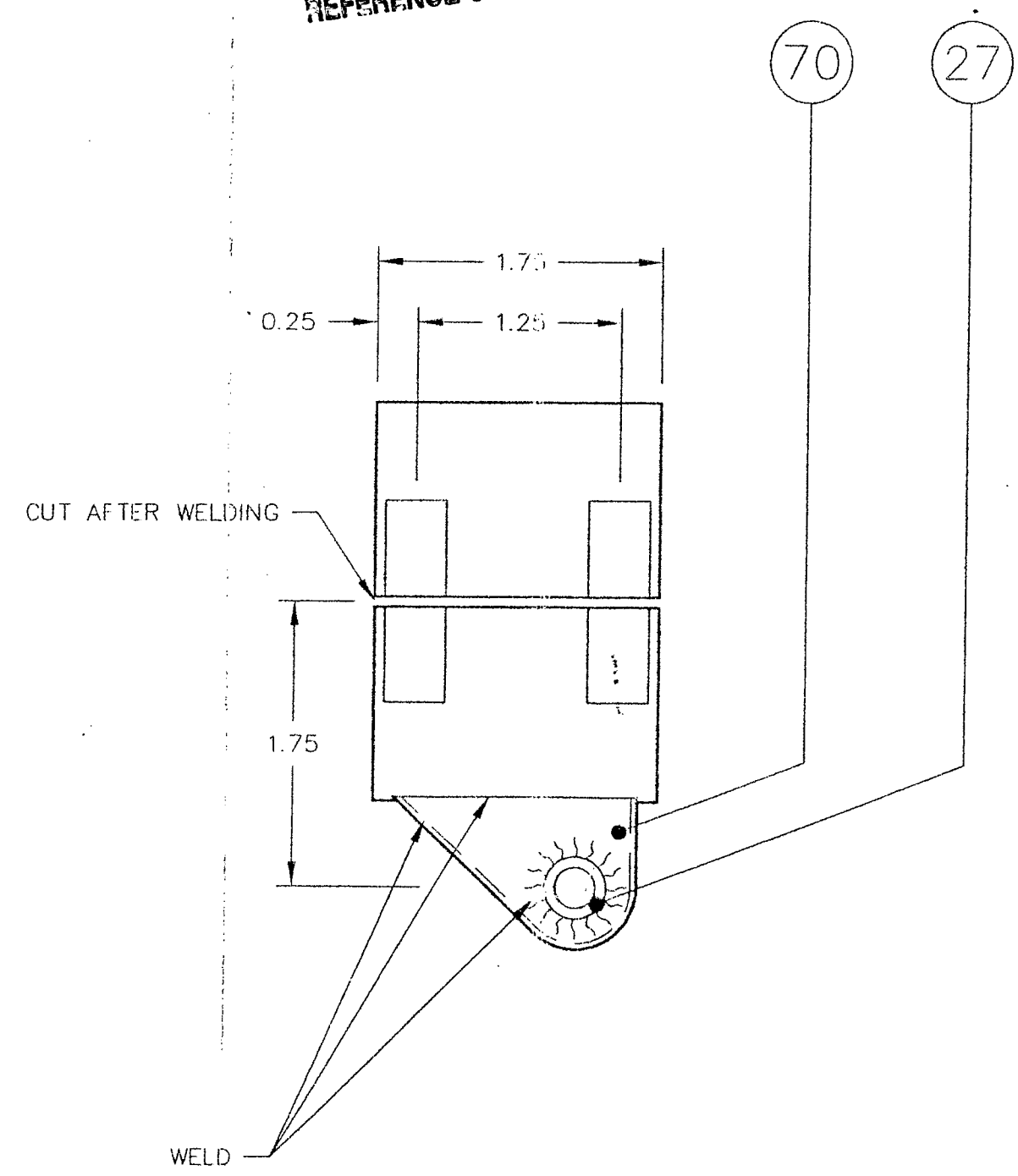
80624
47908

1	LUG, ITEM 70, MODIFIED. THICKNESS OF BRKT CHANGED TO 0.38".	E. B.	27 DEC 92
2	NOTE RE. WELD BEADS ADDED TO ITEM 68	D. W.	6 OCT 00

47908



REFERENCE ONLY



(68) BRACKET

AS350-9267

47908

NOTES

- 1. TIG WELD AS PER MIL-E-23765/1B, CLASS MIL-E-705-2.
USE FILLER ROD MIL-R-5632, CLASS 2, TYPE 1 (AMS 6457A)
- 2. FILLET EDGE OF CLAMP ALONG 2.38 I.D. SECTION TO 1/32" RADIUS
TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE.
FILLET BOTH TOP AND BOTTOM EDGES.
- 3. THOROUGHLY CLEAN AND DEGREASE ITEM 68. PRIME
AND PAINT TO AS PER EXISTING AIRCRAFT COLOR REQUIREMENTS.

REFERENCE ONLY

	4	AN4-17A	31	BOLT			
	8	AN960-416	30	WASHER			
	4	MS20365-428	29	NUT			
	2	AS350-92-28	28	RUBBER PAD SEE DWG. AS350-9228			
1		AS350-92-27	27	BUSHING SEE DWG. AS350-9227			
2			70	LUG	4130 COND. N SHEET	MIL-S-18729	0.063 THK.
1			69	STRIP	4130 COND. N SHEET	MIL-S-18729	0.036 THK.
4		AS350-92-63	63	BUSHING SEE DWG. AS350-9263			
1		AS350-92-62	62	TUBE SEE DWG. AS350-9262			
	1		68	BRACKET			
		AS350-92-67	67	ATTACHMENT BRKT ASSEMBLY			
68	67	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
QTY.		LIST OF MATERIALS					

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1

APPROVALS	DATE
DRAWN: E. BURGOIN	15 DEC 92
CHECKED:	
STRESS:	
FLIGHT TEST:	

AERO DESIGN LTD.

1055 McTAVISH ROAD N.E.
CALGARY, ALBERTA T2E 7G9

EAGLE COPTERS LTD.

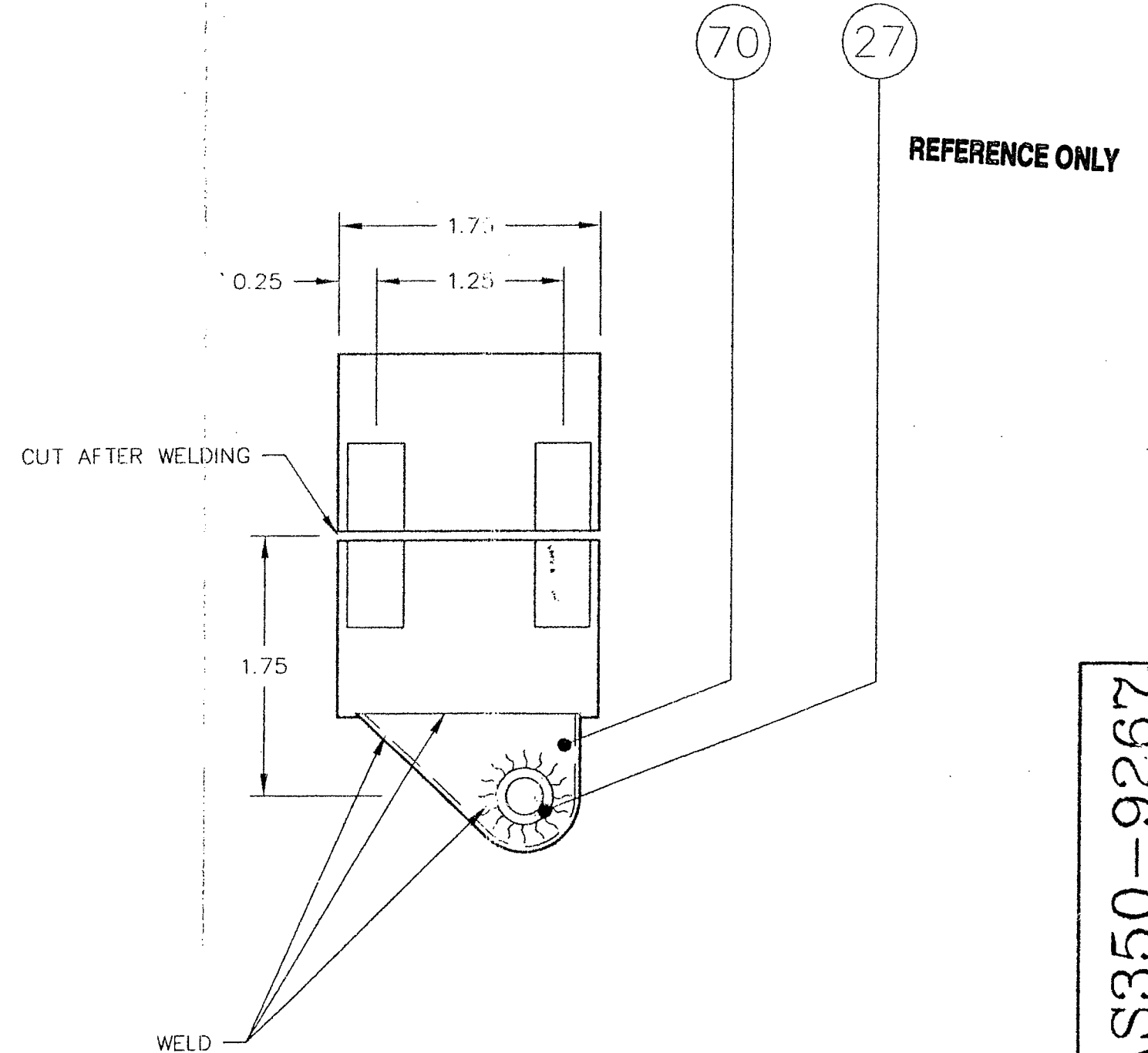
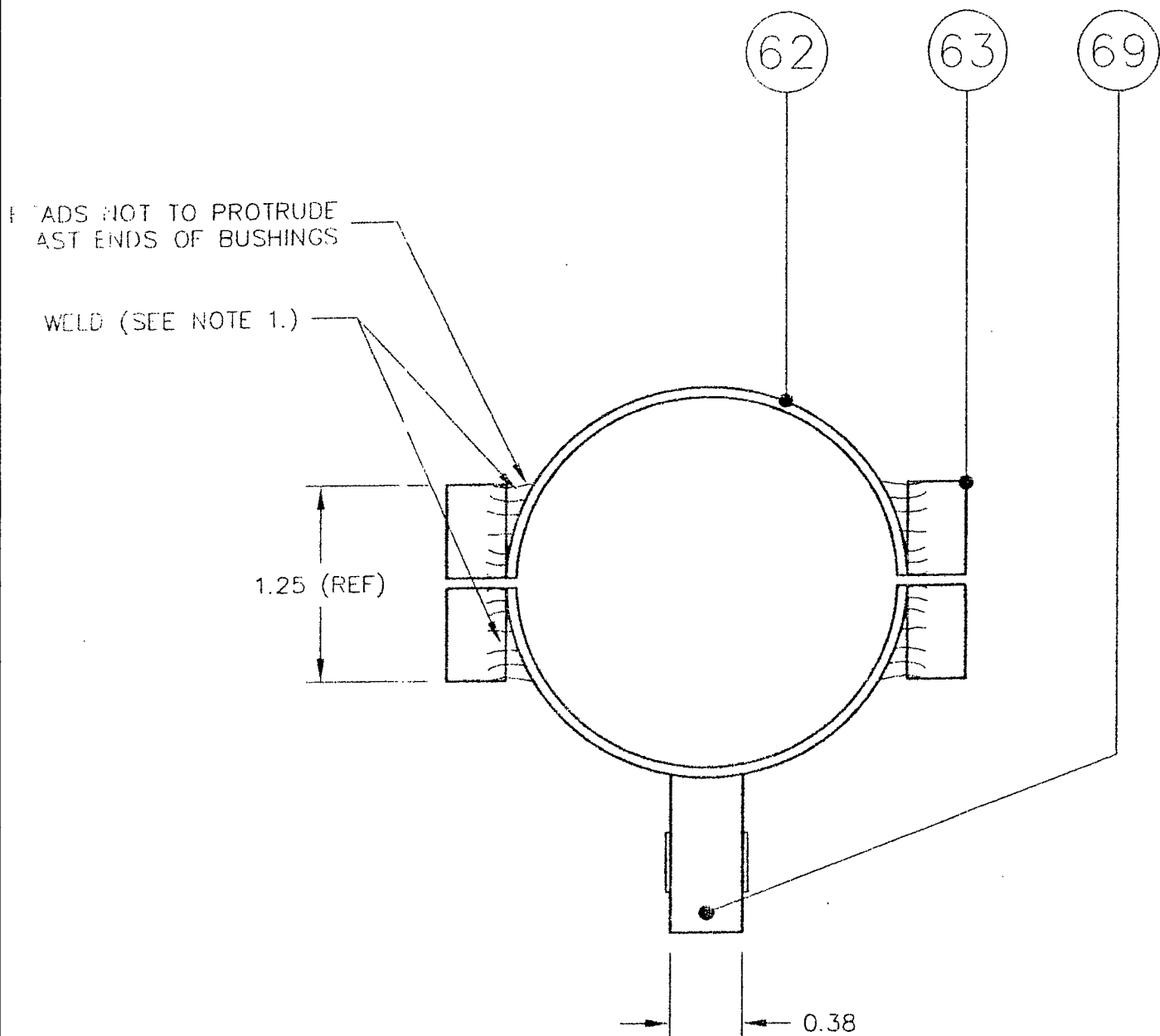
823 McTAVISH RD. N. E.
CALGARY, ALBERTA T2E 7G9

**AS350 & AS355 CARGO BASKET
ATTACHMENT BRKT ASSEMBLY**

SCALE 1 : 1	SIZE	DWG. NO.	REV.
SHEET 1 OF 1	D	AS350-9267	2

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUG, ITEM 70, MODIFIED. THICKNESS OF BRKT CHANGED TO 0.38".	E. B.	27 DEC 92
2	NOTE RE. WELD BEADS ADDED TO ITEM 68	D. W.	6 OCT 00

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AS350-9267

(68) BRACKET